Ship Wed.

Rev B Dwg.

~~PRELIMINARY ISSUE~~

Work Order ID 120034

120034

June-03-14 9:25:13 AM

Item ID: D4979-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 6/03/14 **Start Qty:** 3.00 *3* **Cust Item ID:**

Required Date: 6/03/14 **Req'd Qty:** 3.00 *3* **Customer:**

Reference:

Run Start *NR1*

Approvals: **Process Plan:** W **Date:** **Tooling:** **Date:** **Stop** *NR2*

QC: **Date:** **SPC (Y/N):** **Date:**

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D4979	**Revision Nbr** ~~PB1~~ Rev B 5/14/2/06								
100	FLOW WATER JET	0.00				4	0		JM14-06-3
100 Waterjet	**Memo**	0.00							
FLOW CNC Waterjet 304.063"	1-Cut D4979-1 as per Dwg Dwg Rev: B3/ Prog Rev: B3/								
	2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00				4	0		JM14-06-3
110 QC	**Memo**	0.00							
Quality Control									

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

- Rework ☐
- Scrap ☐
- Use-as-is ☐
- Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

- Skid-tube ☐
- Machining ☐
- Thermoforming ☐
- Large Fab ☐
- Crosstube ☐
- Small Fab ☐
- Finishing ☐
- Composite ☐
- Water Jet ☐
- Prod. Eng. Coor. ☐
- Rec/Store/Packaging ☐
- Supplier ☐
- Engineering ☐
- Quality ☐
- Other ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

- ☐ Bending
- ☐ Centre Not Concentric
- ☐ Cracks
- ☐ Crimp/Kink/Ripple/Wave
- ☐ Cuffs
- ☐ Crushing
- ☐ Heat Treat
- ☐ Inspection Strip in Tube
- ☐ Marks/Chatter
- ☐ Turning Sequence
- ☐ Wave/Twist in Tube

General

- ☐ Bend
- ☐ BOM/Route
- ☐ Broken/Damage/Defect
- ☐ Burrs
- ☐ Contamination
- ☐ Countersink
- ☐ Cut Too Short
- ☐ Drawing
- ☐ Drill Holes
- ☐ Finish
- ☐ Fit/Function
- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Work Order ID 120034

120034

June-03-14 9:25:13 AM

Item ID: D4979-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 6/03/14 **Start Qty:** 3.00 *3*

Required Date: 6/03/14 **Req'd Qty:** 3.00 *3*

Cust Item ID:

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC8- Inspect parts - second check	0.00 DAS 27 9-89				4			
120 QC Quality Control	**Memo**	0.00 M/6/13				Inspect as per Rev PPS1			
130	Bend as per dwg NC BRAKE	0.00				4			8/14/06/03
130 Brake NC Brake NC	**Memo**	0.00							
140	QC5- Inspect part completeness to step on W/O	0.00 SHP							
140 QC Quality Control	**Memo**	0.00 M/6/13				4 Inspect as per Rev PPS1			

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

DART AEROSPACE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

☐ Bending
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General

☐ Bend
☐ BOM/Route
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☐ Countersink
☐ Cut Too Short
☐ Drawing
☐ Drill Holes
☐ Finish
☐ Fit/Function
☐ Folio/Program
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☐ Hardware
☐ Inspection Incomplete/Unqualified
☐ Instructions Incomplete/Unclear
☐ Misaligned/off center
☐ Mislabeled
☐ Misread
☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other

Work Order ID 120034

120034

June-03-14 9:25:13 AM

Item ID: D4979-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 6/03/14 **Start Qty:** 3.00 *3* **Cust Item ID:**

Required Date: 6/03/14 **Req'd Qty:** 3.00 *3* **Customer:**

Reference: **Run Start** *NR1*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____ **Stop** *NR2*

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Small Fab Small Fab		0.00				3			CR 1706-04
	Memo 1- PRIME AS PER DWG PRIME IAW MIL-P-23377J TYPE 1 CLASS N BATCH: 127401	0.00							
160 *160* QC Quality Control	QC14- Inspect Spray Paint	0.00				3			DAS 27 9-89
	Memo	0.00				Inspect as per Dwg PB1			14/06/14
170 *170* Packaging Packaging	Identify as per dwg & Stock Location ~~CC-CW~~ ST129	0.00				3			DAS 33 9-89 14-08-06
	Memo	0.00							

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐
Suspected Unapproved ☐

AGAINST DEPARTMENT/PROCESS

Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐
Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐
Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐
Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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General

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☐ Contamination
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☐ Folio/Program
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☐ Hardware
☐ Inspection Incomplete/Unqualified
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☐ Off-set
☐ Out of Calibration
☐ Out of Sequence
☐ Outside Dimensions
☐ Over/Under tolerance
☐ Part Incorrect
☐ Part Lost/Missing
☐ Part Moved
☐ Positioned Wrong
☐ Power Loss/Surge
☐ Pressure/Forced
☐ Set-up
☐ Temperature/Cure
☐ Weld
☐ Wrong Stock Pulled
☐ Other _____

Work Order ID 120034

120034

June-03-14 9:25:13 AM

Item ID: D4979-2 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Bracket

Start Date: 6/03/14 **Start Qty:** 3.00 *3*

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Cust Item ID:

Customer:

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Run Start *NR1*

Stop *NR2*

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

QC: _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	QC21- Final Inspection - Work Order Release	0.00					14/8/6		
180									
QC	Memo	0.00							
Quality Control									

14-6-4

POSITIVE RECALL
EFFECTIVE 140603 AUTH
RELEASED DATE 14/06/06
Reinspect to Rev B Dwg

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date: Work Order update only ☐

Work Order: _____

Part No. _____

NCR No. _____

DISPOSITION

Rework	☐
Scrap	☐
Use-as-is	☐
Suspected Unapproved	☐

AGAINST DEPARTMENT/PROCESS

Skid-tube	☐	Crosstube	☐	Water Jet	☐	Engineering	☐
Machining	☐	Small Fab	☐	Prod. Eng. Coor.	☐	Quality	☐
Thermoforming	☐	Finishing	☐	Rec/Store/Packaging	☐	Other	☐
Large Fab	☐	Composite	☐	Supplier	☐		☐

Root Cause		Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design	☐									
Doc/Data	☐									
Equip/Tooling	☐									
Handling/Pre	☐									
Material	☐									
Operator	☐									
Offset/Setup	☐									
Process	☐									
Supplier	☐									
Training	☐									
Transport	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear

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- ☐ Folio/Program
- ☐ Grain
- ☐ Hardware
- ☐ Inspection Incomplete/Unqualified
- ☐ Instructions Incomplete/Unclear
- ☐ Misaligned/off center
- ☐ Mislabeled
- ☐ Misread
- ☐ Off-set
- ☐ Out of Calibration
- ☐ Out of Sequence
- ☐ Outside Dimensions
- ☐ Over/Under tolerance
- ☐ Part Incorrect
- ☐ Part Lost/Missing
- ☐ Part Moved
- ☐ Positioned Wrong
- ☐ Power Loss/Surge
- ☐ Pressure/Forced
- ☐ Set-up
- ☐ Temperature/Cure
- ☐ Weld
- ☐ Wrong Stock Pulled
- ☐ Other _____

Picklist Print

June-03-14 9:24:15 AM

Work Order ID: 120034 *120034*

Parent Item: D4979-2 *D4979-2*

Parent Item Name: Bracket

Start Date: 6/03/14 **Required Date:** 6/03/14

Start Qty: 3.00 **Required Qty:** 3.00

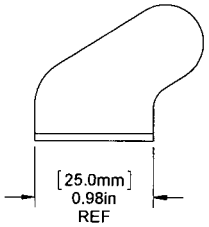
Comments: IPP REV:A 13.11.18 NEW ISSUE DD VERF:JLM

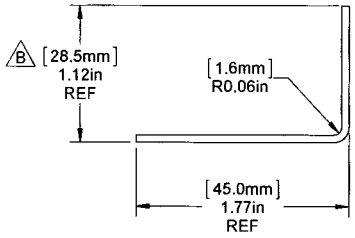
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S16GA		Purchased	No				sf	217.8670		1			
M304S16GA									**				
304/316 Sheet .063													

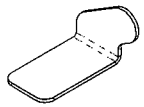
JM14-06-3

Location	Loc Qty	Loc Code
MAT020	217.867	
M127821	75.567	
M128423	1.2	
M129192	141.1	

129192

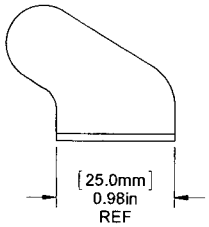


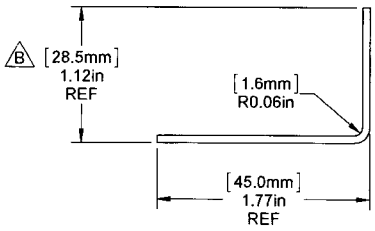


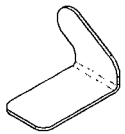


D4979-1 BRACKET

w/o 120034







D4979-2 BRACKET

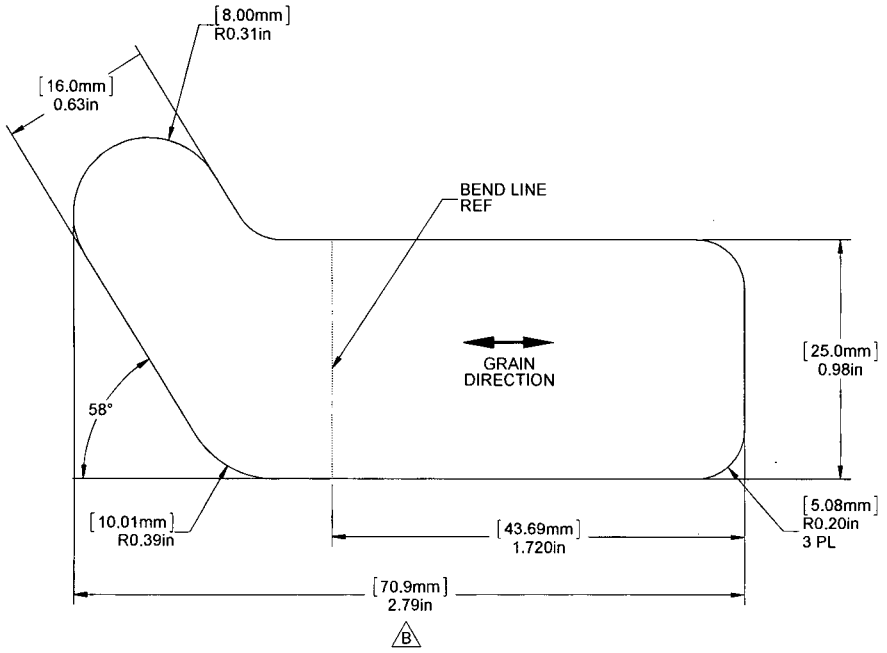
NOTES:
1) MATERIAL: MAKE FROM D4979-1F
2) FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4979-1" OR "D4979-2", AGUSTA WESTLAND P/N "TBD", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
7) WEIGHT: 0.05 lbs (0.02 kgs)

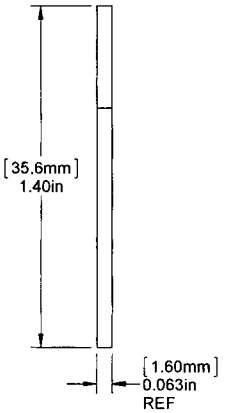
REV.	DESCRIPTION	BY	DATE
B	REVISED D4979 -1/-2 OVERALL HEIGHT (ZN B5-1, ZN D5-1, ZN B5-2)	AK	14.05.30
A	NEW ISSUE	DC	13.11.13

UNAPPROVED

DESIGN	DC	**DART AEROSPACE LTD**
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D4979 REV. B
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE BRACKET SCALE NTS
DE APPR.	DS	
DATE	14.05.30	

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D4979-1F FLAT PATTERN BRACKET

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 lbs (0.02 kgs)
8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4979-1-b.IGES

UNAPPROVED

DESIGN	DC	**DART AEROSPACE LTD**
DRAWN	DC	HAWKESBURY, ONTARIO, CANADA
CHECKED	RF	DRAWING NO. D4979 REV. B
MFG. APPR.	JLM	SHEET 2 OF 2
APPROVED	HS	TITLE BRACKET SCALE NTS
DE APPR.	DS	
DATE	14.05.30	

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DART AEROSPACE LTD	Work Order:	120034
Description: Bracket	Part Number:	04979-2
Inspection Dwg: 04979 Rev: P8		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.63"	±0.030"	0.631"	–		V	JKm06
2.79"	"	2.795"	–		V	
0.98"	"	0.990"	–		V	
0.063"	±0.010"	0.058"	–		V	

Measured by:	JM	Audited by:	JM	Preliminary Approval:	
Date:	14-06-3	Date:	14-Jun-7	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

DART AEROSPACE LTD

DART AEROSPACE

Description: Bracket Work Order: 1/20347

Inspection Drawing: 4975 Rev: P61 Part Number: D 4979-2

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.77	+/-.03	1.773	✓		V	SB-11
1.12	+/-.03	1.41	✓		V	SB-11

Measured by:	Checked By:	QC inspector	Engineering Approval (*if necessary*)
Date 14/06/03	DAS 36 9-89 Date 14/06/03	DAS 27 9-89 Date 14/6/13	Date

Purchase Order Receipt Listing

Friday, May 16, 2014 9:51:45 AM

All amounts are calculated in domestic currency.

All Vendors PO ID PO23746 Receipt Dates from 5/16/2014 to 5/16/2014 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M / Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
Vendor ID\Vendor Name		**VC-COP001**	**Thyssenkrupp Materials CA Ltd**								
PO23746	1		M304S16GA	sf	4/17/2014	5/16/2014	224.0000	$3.90	0.0000	0	$872.92
CAD	No		304S16 Sheet .063	sf	224.0000	DESJ02		$872.92	0.0000	0	
			m129192								
	6		71401-45		4/17/2014	5/16/2014	1.0000	$0.00	0.0000	0	$0.00
	No		Procurement Quality Clauses		1.0000	DESJ02		$0.00	0.0000	0	
			m129192								

Total Received Quantity:	225.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	$872.93
Total Balance Due Quantity:	0.0000

B I L L O F L A D I N G

No: PEC 877147
Ship Date 13May14 at 9:27 From PFW
Probill
Via VIM DELIVERY
FOB CONCORD
Frt PREPAID
Route 0- 0 Manifest
Vhcle Trailer
Slp STAN IVERS (905-532-1350)
Sold To: (20115)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7

Ship From:
THYSSENKRUPP MATERIALS NA
2821 LANGSTAFF ROAD
CONCORD, ONTARIO L4K 5C6
Tel: 905 669 9444 Fax: 905-738-9033

Ship To: (1)
DART AEROSPACE
1270 ABERDEEN ST
HAWKESBURY, ON K6A 1K7
Tel: 613-632-9577 Fax: 613-632-1053

==========

B I L L O F L A D I N G

1) Our Order PEC-671461- 1 Your PO # 23746

MTR

STAINLESS STEEL SHEET 304 2B
.0600-Nom X 48.0000" X 96.0000"

Heat Number	Tag No	Quantity	PCS	Wt LBS
884227	291595	224.00 SFT	7	539

	Tags	PCS	LBS
TOTAL:	1	7	539

MILL TEST REPORTS, PACKING SLIPS ARE TO SENT
WITH MATERIAL AND FAXED TO THE CUSTOMER PRIOR
TO SHIPPING.
ATTN: CHANTAL/LINDA
** ALL PACKING SLIPS MUST HAVE THE HEAT NUMBER **
** REFERENCED ON IT **

BACK ORDER FROM OUR PREVIOUS B/L# 872577
TOTAL 1 SKID GW. 604 LBS

*CUSTOMER PICK-UP HRS AT THYSSENKRUPP MATERIALS NA
CONCORD, ONT.* *** 9:00 AM TO 4:00 PM ***
**** TEL. 800-926-2600 ****

* WE STOCK STAINLESS STEEL *
* PLEASE LET US QUOTE YOUR NEXT REQUIREMENT *

***PLEASE NOTE A $25.00 ENERGY SURCHARGE WILL BE
ADDED TO EVERY ORDER.***

Page: 1 Last

TOUTES ERREURS ET/OU MARCHANDISES MANQUANTES DOIVENT ETRE RAPPORTÉES IMMÉDIATEMENT.
ERRORS OR SHORTAGE MUST BE REPORTED IMMEDIATELY
RETOUR DE MARCHANDISES AVEC NOTRE NUMERO D'APPROBATION SEULEMENT.
MERCHANDISE MAY NOT BE RETURNED WITHOUT OUR APPROVAL NUMBER

REÇU EN BONNE CONDITIONS / RECEIVED IN GOOD CONDITION

DATE

X4586

Rec 258135-1

CCC 824027.PM

Herstellwerk / Manufacturer's works / Usine productrice

outokumpu

/ Art der Prüfbescheinigung / Type of inspection document / Type de document

ABNAHMEPRUEFZEUGNIS
INSPECTION CERTIFICATE
CERTIFICAT DE RECEPTION
nach / according to / suivant
EN 10204-3.1

Ausstellungsdatum / Date of issue / Date d'émission
Nummer des Dokuments / Numéro de document
1000496333 /
Seite / Page / Page
1 / 1

Oberschlesienstrasse 16, 47807 Krefeld

OUTOKUMPU STAINLESS USA, LLC
1 ThyssenKrupp Drive
CALVERT, ALABAMA AL 36513-1300
USA

Besteller/Empfänger / Customer/Consignee / Acheteur/Destinataire
OUTOKUMPU STAINLESS USA, LLC,Calvert, Ala

Kundenbestellnr. / Customer's order number / Numéro de la commande du client
51004304

Werksauftragsnr. / Manufacturer's works order no / N° de la commande de l'usine productrice
900453432 / 001

Lieferanzeige Nr. / Delivery Note No. / Avis d'expédition N°
87627406 / 010

Erzeugnis / Product / Produit
BLECH/SHEET/TOLE

Lieferbedingungen / Terms of delivery / Conditions de livraison
ASTM A 666
SAE AMS 5513 J
ASTM A 240/A 240M
ASME SA 240/SA 240M Sec II Part A Ed.2013

Stahlsorte und Gütegruppe / Steel grade and quality
Type 304

Kundenmaterial-Nr. Customer's material number N° de matière du client	Maße des Erzeugnisses (Dicke / Breite / Länge) Product dimensions (Thickness / Width / Length) Dimensions du produit (Epaisseur / Largeur / longueur)	Herstellart Steelmaking proc. Mode d'élabor.	Auftragsnr. Order Ordre
P003389	0.0579 inch x 48.0000 inch x 96.0000 inch	AOD	IIIc / 2B

Paket-Nr. Packing-No N° Paquet	Stückzahl No of pieces N° de pièces	Ist-Gewicht Actual weight Masse effective	Ident.-Nr. Erzeugnis Ident.-No of product Ident.-N° du produit	Schmelzen/ Cast number Id. de la coulée	Proben-Nr. Sample-No. Emplacement du prélèvement	Proben-Nr. Sample-Id. Emplacement du prélèvement
8702379	52	4.017 lbs	278676	884227	1002875783	1002875784
8702380	52	3.995 lbs	278676	884227	1002875783	1002875784
	104	8.012 lbs				

Chemische Zusammensetzung / Chemical composition

Schmelzen-/ Cast no.	% C	% Si	% Mn	% P	% S	% Cr	% Ni	% N	% Mo	% Cu
884227	0.033	0.38	1.28	0.027	0.0040	18.13	8.50	0.040	0.20	0.44

Prüfort/Inspection lot Lot de contrôle: QUER

Proben-Ident-Lage Sample Id./-Position Identification du prélèvement	YS0,2% PSI	YS1,0 PSI	TS PSI	El. A2" %	HV HV	HRB HRB				
1002875783	43365	47135	89485	58.8	173	80.0				
1002875784	43655	47280	89485	59.5	170	80.0				

Beschreibung gegen interkrist. Korrosion/Description against intercrystalline corrosion/Description à la corrosion intercristalline: EN ISO 3651-2 I.O.

ASTM A 262 PRACTICE E I.O.

Maße-Oberfläche/Dimensions-Surface/Dimensions-Surface: I.O.

Werkstoffprüfung (Spektralanalyse)/Test of identity(spectrum analysis)/Contrôle d'identification (analyse spectrale): I.O.

WAERMEBEHANDLUNG : 1050 GRAD C / LUFT

TRAITEMENT THERMIQUE : 1050 GRAD C / AIR

HEAT - TREATMENT : 1050 DEGREE / AIR

Aussteller der Bescheinigung/ Originator of the document / Auteur du document

Outokumpu Nirosta GmbH
Dieses Zeugnis wurde
maschinell erstellt
Werk Krefeld

Abnahmebeauftragter/ Inspection Expert
Ulrich Wienert
Tel.: 49-2151-83-3142
Fax: 49-2151-83-4126
Certificates.Nirosta@outokumpu.com

Stempel der/des Abnahmebeauftragten
Receiving agent's stamp
Poinçon de l'agent réceptionnaire

QA

Datum der Ausstellung und Bestätigung
Date of issue and validation
Date d'émission et validation: 15.11.2013

DART AEROSPACE

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

14/04/16

Contact Name		**Buyer**	Chantal Lavoie
Vendor Phone	905 669 9444	**Customer POID**	
		Customer Tax #	10127-2607
Ship To Contact		**Terms**	Net 30
Ship To Phone		**Currency**	CAD
Ship Via:	VENDOR'S TRUCK	**FOB**	FCA – (Free Carrier)
Ship Acct:			

Line Nbr	Reference / Vendor Part Number / Line Comments / Delivery Comments	Description/ Mfg ID	Req Date/ Taxable / Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	M304S16GA	304/316 Sheet .063	4/17/2014 Yes 4/17/2014		224.00 sf	$4.27	
	MATERIAL; AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						
						Line Total:	
2	M304S18GA	304/316 .050 Sheet	4/17/2014 Yes 4/17/2014		224.00 sf	$3.45	
	MATERIAL; AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						
						Line Total:	

PO Instructions: quotation:
no: pec st-0670569

Note:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905 669 9444
Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

3	M2024T3S.020	Alum. sheet .020	4/17/2014 Yes 4/17/2014	48.00 sf	✓	$4.33	$2

MATERIAL: 2024-T3 ALUMINUM SHEET
AS PER QQ-A-250/4 OR AMS-QQ-A-250/4 OR
AMS 4037 OR ASTM B209

14/4/23

Line Total: $208.

4	M6061T6S.063	6061-T6 .063 Sheet	4/17/2014 Yes 4/17/2014	320.00 sf	✓	$3.31	$1,0

MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209

Line Total: $1,0

5	M6061T6S.080	6061-T6 .080 Sheet	4/17/2014 Yes 4/17/2014	336.00 sf	✓	$4.13	$1

MATERIAL: 6061-T6/T62 ALUMINUM SHEET
AS PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209

14/4/23
VEC 2-8

PO Instructions: quotation:
no: pec st-0670569

Note:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO23746

Purchase Order Date 4/10/2014
PO Print Date 4/10/2014

Order From : VC-COP001

THYSSENKRUPP MATERIALS CA LTD
O/A VPK METAL- C/O T27540/PO BOX 4275,POSTAL"A"
TORONTO, ON M5W 5V8
CA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name
Vendor Phone 905 669 9444

Ship To Contact
Ship To Phone
Ship Via: VENDOR'S TRUCK
Ship Acct:

Buyer Chantal Lavoie
Customer POID
Customer Tax # 10127-2607
Terms Net 30
Currency CAD
FOB FCA – (Free Carrier)

Line Total: $1,386.00

6	71401-45	Procurement Quality Clauses	4/17/2014 No 4/17/2014	1.00		$0.00

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart notification by supplier
A043 retention of quality document

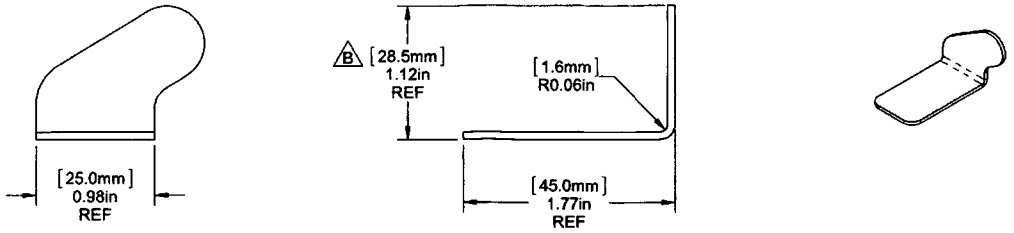
Line Total: $0.00

PO Total: $4,386.00

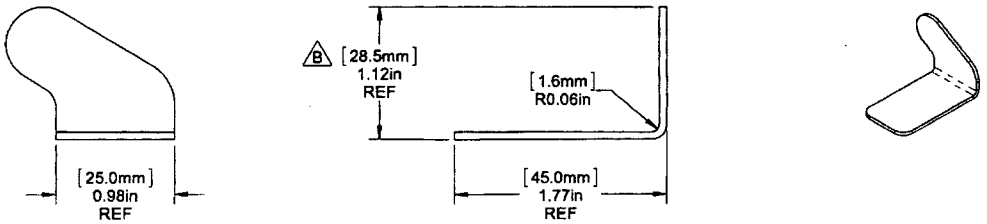
PO Instructions: quotation:
no: pec st-0670569

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explaination.

Change Nbr: 2 **Change Date:** 4/10/2014



D4979-1 BRACKET



D4979-2 BRACKET

RELEASED
2014 -06- 11

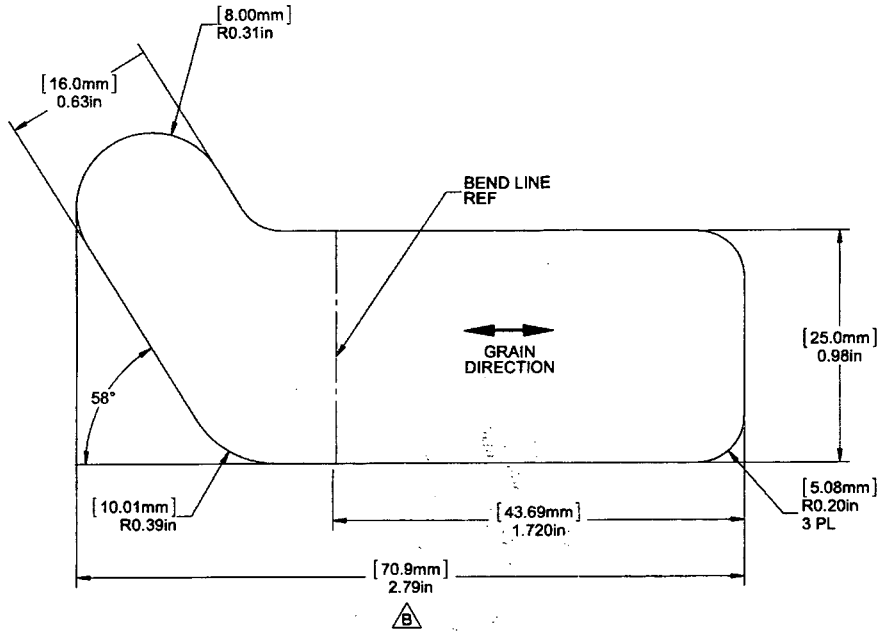
NOTES:
1) MATERIAL: MAKE FROM D4979-1F
2) FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX, AS PER QSI 005.
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4979-1" OR "D4979-2", REVISION, BATCH NUMBER AND DATE OF MANUFACTURE, USING AN X-TENSION STAMP, PER QSI 044 METHOD 6.2
7) WEIGHT: 0.05 lbs (0.02 kgs)

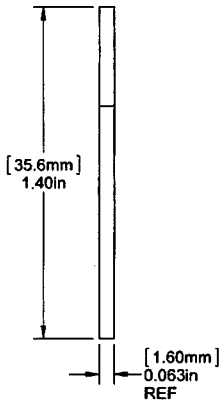
REV.	DESCRIPTION	BY	DATE
B	REVISED D4979 -1/-2 OVERALL HEIGHT (ZN B5-1, ZN D5-1, ZN B5-2)	AK	14.05.30
A	NEW ISSUE	DC	13.11.13

APPROVED

DESIGN	DC	DART AEROSPACE LTD
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA
CHECKED	HS	DRAWING NO. D4979 — REV. B
MFG. APPR.	JLM	SHEET 1 OF 2
APPROVED	HS	TITLE BRACKET — SCALE NTS
DE APPR.	DS	
DATE	14.05.30	

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D4979-1F FLAT PATTERN BRACKET

RELEASED
2014 -06- 1

NOTES:
1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET ANNEALED 2B FINISH, 16 GAUGE (0.063 THICK)
PER AMS 5513 (304) OR 5524 (316) OR ASTM A240 OR ASME SA240
REF DART SPEC. M304S16GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT: 0.05 lbs (0.02 kgs)
8) UNDIMENSIONED FEATURES CONTROLLED BY CAD MODEL FILE: D4979-1-b.IGES

APPROVED

DESIGN	DC
DRAWN	RF
CHECKED	HS
MFG. APPR.	JLM
APPROVED	HS
DE APPR.	DS
DATE	14.05.30

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4979 REV. B
SHEET 2 OF 2
TITLE BRACKET SCALE NTS

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